

Work Order ID 83335

April-17-12 1:32:02 PM

83335

Page 1

Item ID: D4522-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base Plate, OEM, LH

Start Date: 4/17/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4522

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

6061.175

Prog Rev: A

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-17

①

B12-4-17

Work Order ID 83335***83335***

Page 2

Item ID: D4522-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base Plate, OEM, LH

Start Date: 4/17/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1-COUNTER SINK AS PER DWG

2-REAM HOLE USING .625" REAMER

Reame

12-4-18

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

(X)

(X)

/

(X)

12/04/18

Work Order ID 83335***83335***

Page 3

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Start Date: 4/17/12 Start Qty: 1.00

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Required Date: 4/18/12 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

151

0.00

151

HAAS 1

HAAS CNC vertical machine #1

Memo

ENGRAVE AS PER DWG AND FOLIO FB083

FOLIO REV: _____

DWG RE: _____

152

0.00

152

QC

Quality Control

QC5-Inspect part completeness to step on W/O

Memo

160

0.00

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

*See final Set only**W*

Work Order ID 83335

April-17-12 1:32:02 PM

83335

Page 4

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N900040100

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

174

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

174

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

176

QC3- Inspect Part Finish

0.00

176

QC

Memo

0.00

Quality Control

Work Order ID 83335

April-17-12 1:32:02 PM

83335

Page 5

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Revision ID:

Stop ***NS2***

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Start Date: 4/17/12 Start Qty: 1.00

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Cust Item ID:

Required Date: 4/18/12 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

Alms

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

RD 3392

u 12-24-19

Picklist Print

April-17-12 1:32:02 PM

Page 1

Work Order ID: 83335

Parent Item: D4522-1

Parent Item Name: Base Plate, OEM, LH

Start Date: 4/17/12

Required Date: 4/18/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-01-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	61.2900	0.301	0.3168421			
6061-T6 .125 Sheet													

B12-4-17

Location

Loc Qty

Loc Code

MAT021

61.29

113608

46.69

118217

0.09

119513

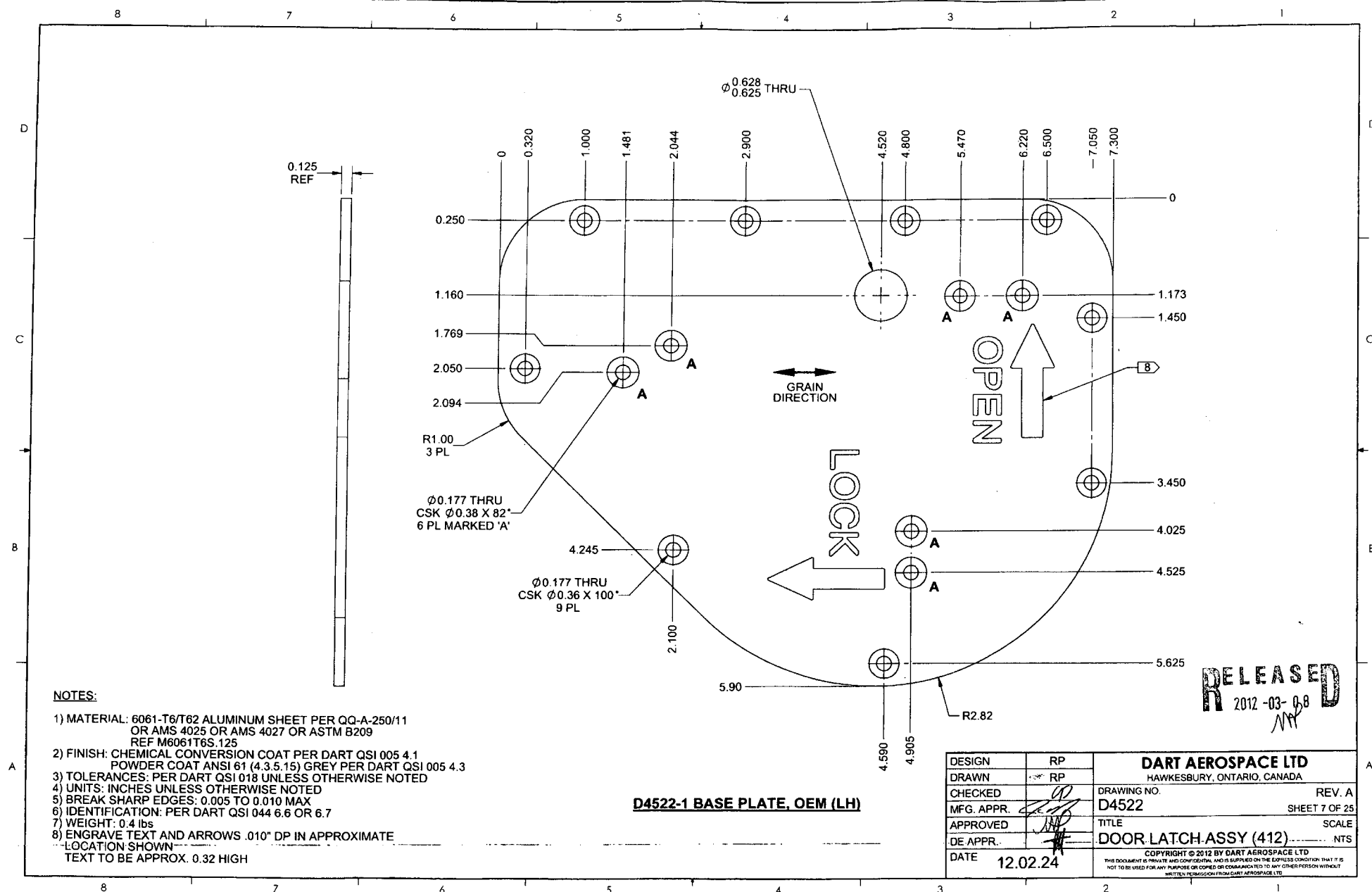
10.8

120218

3.71

170218

6



RELEASED
2012-03-08

DART AEROSPACE LTD		Work Order: 83335
Description: BASE PLATE OEM LH		Part Number: D4522-1
Inspection Dwg: D4522-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 177	+0.05 - .001	178	2		✓ B2	
Ø 625	+0.03 - .001	624	2		✓	
326	± .010	323	2		✓	
1.000	± .010	1.002	2		✓	
1.481	± .010	1.480	2		✓	
2.044	± .010	2.046	2		✓	
2.100	± .010	2.106	2		✓	
2.900	± .010	2.900	2		✓	
4.520	± .010	4.521	2		✓	
4.890	± .010	4.895	2		✓	
4.800	± .010	4.798	2		✓	
4.904	± .010	4.908	2		✓	
5.470	± .010	5.474	2		✓	
6.220	± .010	6.222	2		✓	
6.500	± .010	6.503	2		✓	
7.050	± .010	7.056	2		✓	
7.300	± .010	7.308	2		✓	
250	± .010	251	2		✓	
1.160	± .010	1.157	2		✓	
1.173	± .010	1.174	2		✓	
1.769	± .010	1.770	2		✓	
1.450	± .010	1.447	2		✓	
2.050	± .010	2.054	2		✓	

Measured by: B	Audited by: S	Prototype Approval:
Date: 12-4-17	Date: 12/4/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

